

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10308-041-1	PACKAGING ASSY
-4	1	RB 92700-10308-041-4	INPUT MODULE SEAL INSTALLER ASSY
12	1	RB41011	DART PLACARD
13	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

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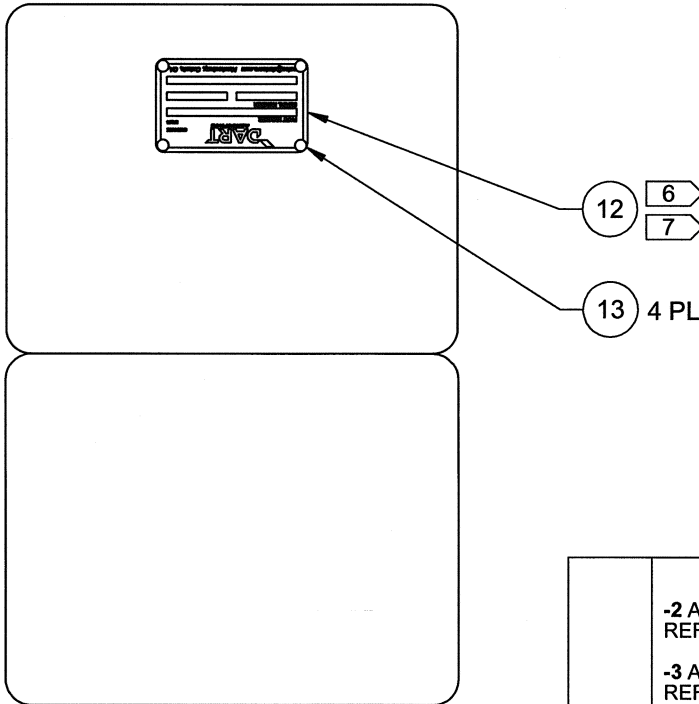
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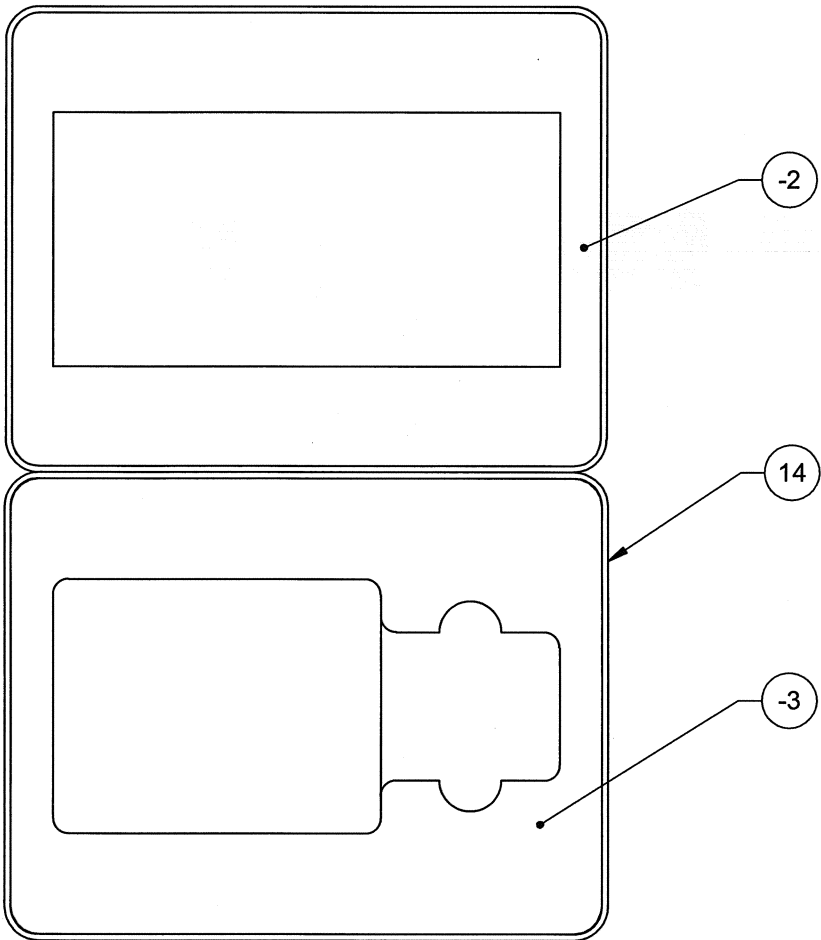
NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED  
7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS  
8) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

**RB 92700-10308-041 INPUT MODULE SEAL INSTALLER**



B	-2 ALL DIMENSIONS ARE NOW IN REFERENCE. DIM WAS 1.18 IS 1.19 REF. DIM WAS R0.43 IS R0.44 REF. CUTOUT DIMENSIONS UPDATED -3 ALL DIMENSIONS ARE NOW IN REFERENCE. DIM WAS 9.34 IS 9.53 REF. DIM WAS 7.16 IS 7.35 REF. DIM WAS R0.43 IS R0.44 REF. CUTOUT DIMENSIONS UPDATED -5 ADDED DIM Ø2.120. DIM WAS 1.80 MEDIUM DIAMOND KNURL IS 1.68 MEDIUM DIAMOND KNURL. ADDED DIM 0.05 x 45.0° CMF. -6 DIM WAS 2.603 REF IS 2.613 REF -7 DIM WAS 2.603 IS 2.613. DIM WAS 2.86 IS 2.784 +0.000/-0.005. DIM WAS 0.125 REF IS 0.130 REF -9 ADDED NOTE 9 -10 ADDED DIM 0.03 X 45.0° CMF 2 PL. DIM WAS 1.30 MEDIUM DIAMOND KNURL IS 1.54 MEDIUM DIAMOND KNURL -11 ADDED DIM 0.03 X 45.0°		19-570	MBB
	A	NEW ISSUE	18-632	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	MBB			
CHECKED	KPT	TOOL PART #	REV. B	
MFG. APPR.	DP	RB 92700-10308-041	SHEET 1 OF 12	
APPROVED	WTP	TITLE	SCALE	NTS
DATE 2/11/2019		SEAL INSTALLER	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10308-041-2	TOP FOAM
-3	1	RB 92700-10308-041-3	BOTTOM FOAM
14	1	PELICAN #APP-1200-E	PELICAN CASE 1200



**RB 92700-10308-041-1 PACKAGING ASSY**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 2 OF 12
APPROVED	VLP	TITLE	SCALE
DATE 2/11/2019		SEAL INSTALLER	NTS
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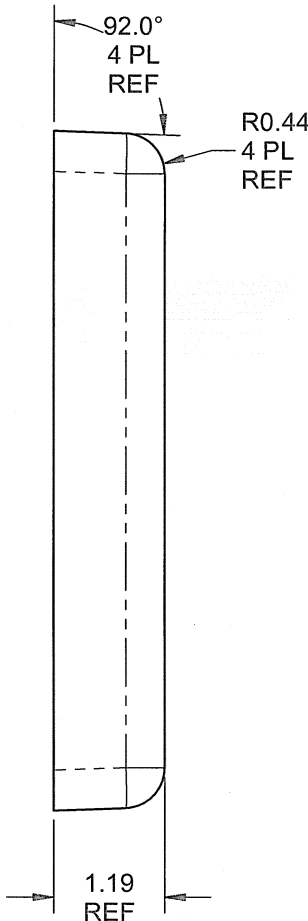
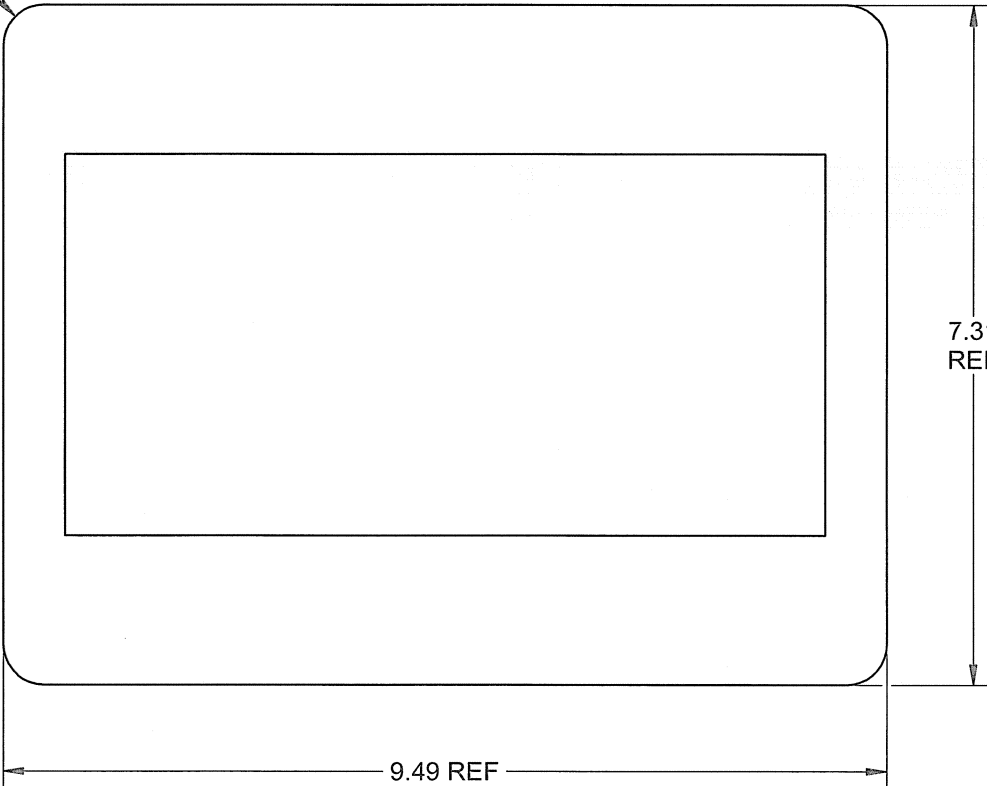
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R0.44  
4 PL  
REF



**RB 92700-10308-041-2 TOP FOAM**

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- NOTES:
- 1) MATERIAL: BLACK ETHAFOAM 220 REF
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10308-041-2 REV. B.STEP

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 3 OF 12
APPROVED	VP	TITLE	SCALE
DATE 2/11/2019		SEAL INSTALLER	NTS
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R0.44  
4 PL  
REF

7.35  
REF

9.53 REF

**RB 92700-10308-041-3 BOTTOM FOAM**

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NOTES:

1) MATERIAL: BLACK ETHAFOAM 220 REF

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10308-041-3 REV. B.STEP

92.0°  
4 PL  
REF

R0.44  
4 PL  
REF

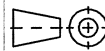
2.93 REF

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DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RB 92700-10308-041</b>	SHEET 4 OF 12
APPROVED	<i>VRP</i>	TITLE	SCALE
DATE <b>2/11/2019</b>		<b>SEAL INSTALLER</b>	NTS 
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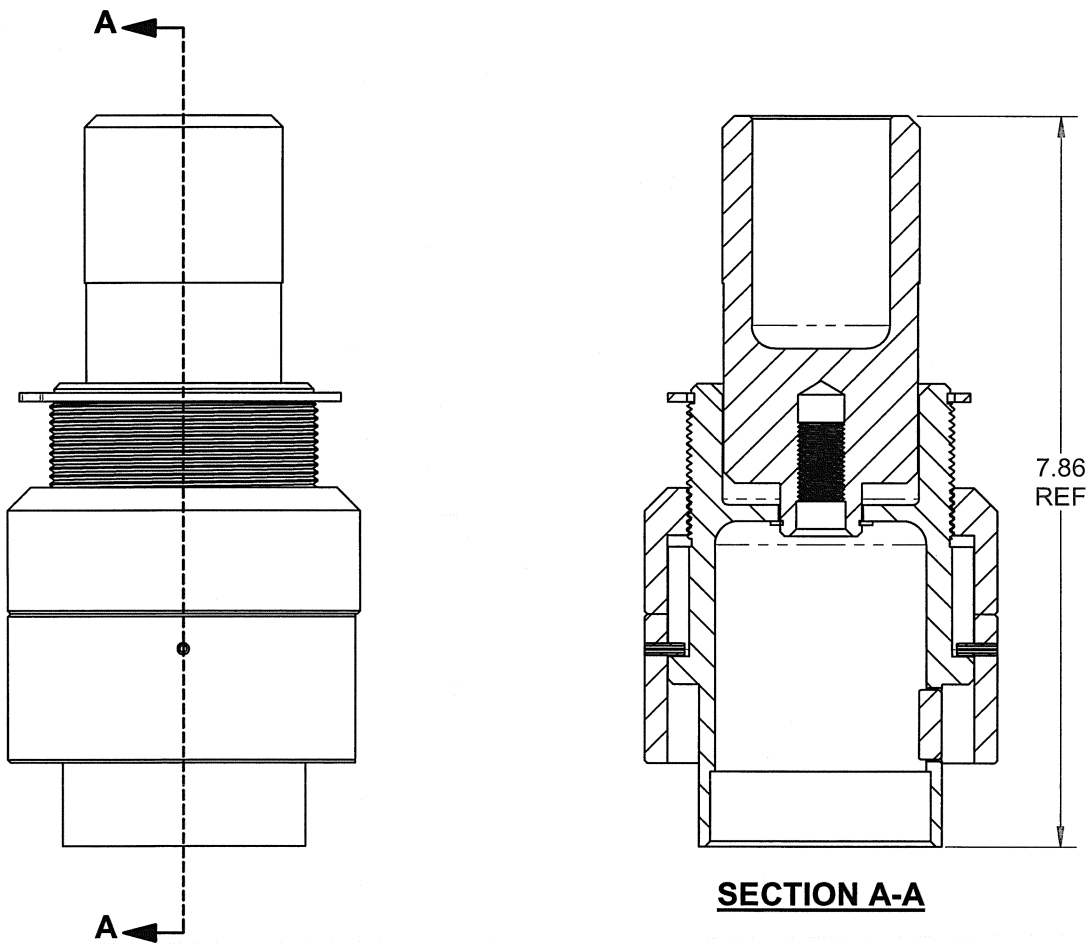
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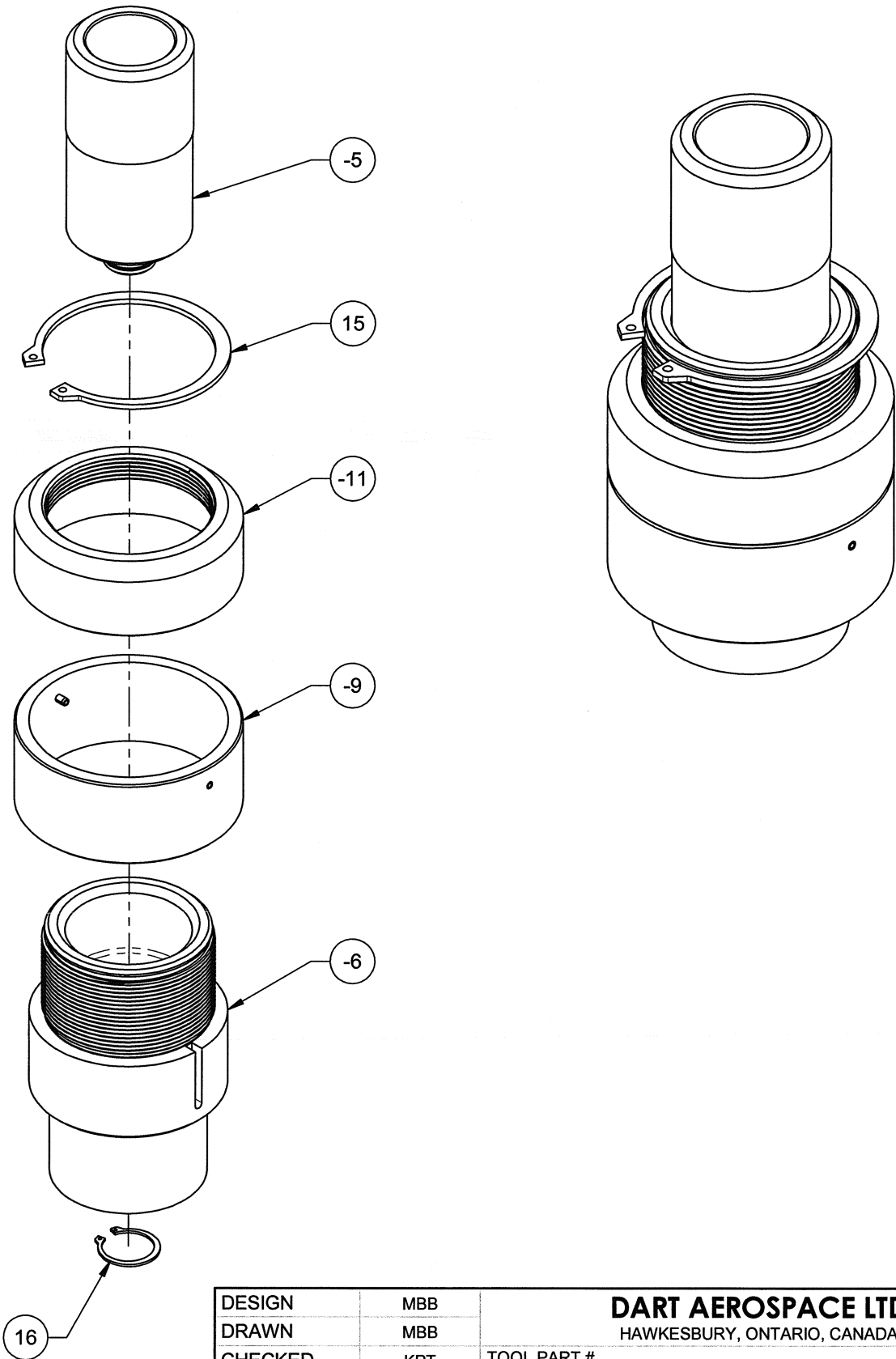
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10308-041-5	PUSHER
-6	1	RB 92700-10308-041-6	SEAL INSTALLER ASSY
-9	1	RB 92700-10308-041-9	ALIGNMENT RING ASSY
-11	1	RB 92700-10308-041-11	THREADED RING
15	1	McMaster#97633A475 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 2-7/8" OD.
16	1	McMaster#97633A270 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 7/8" OD.



RB 92700-10308-041-4 INPUT MODULE SEAL INSTALLER ASSY

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	<b>RB 92700-10308-041</b>	SHEET 5 OF 12
APPROVED	VP	TITLE	SCALE
DATE <b>2/11/2019</b>		<b>SEAL INSTALLER</b>	NTS
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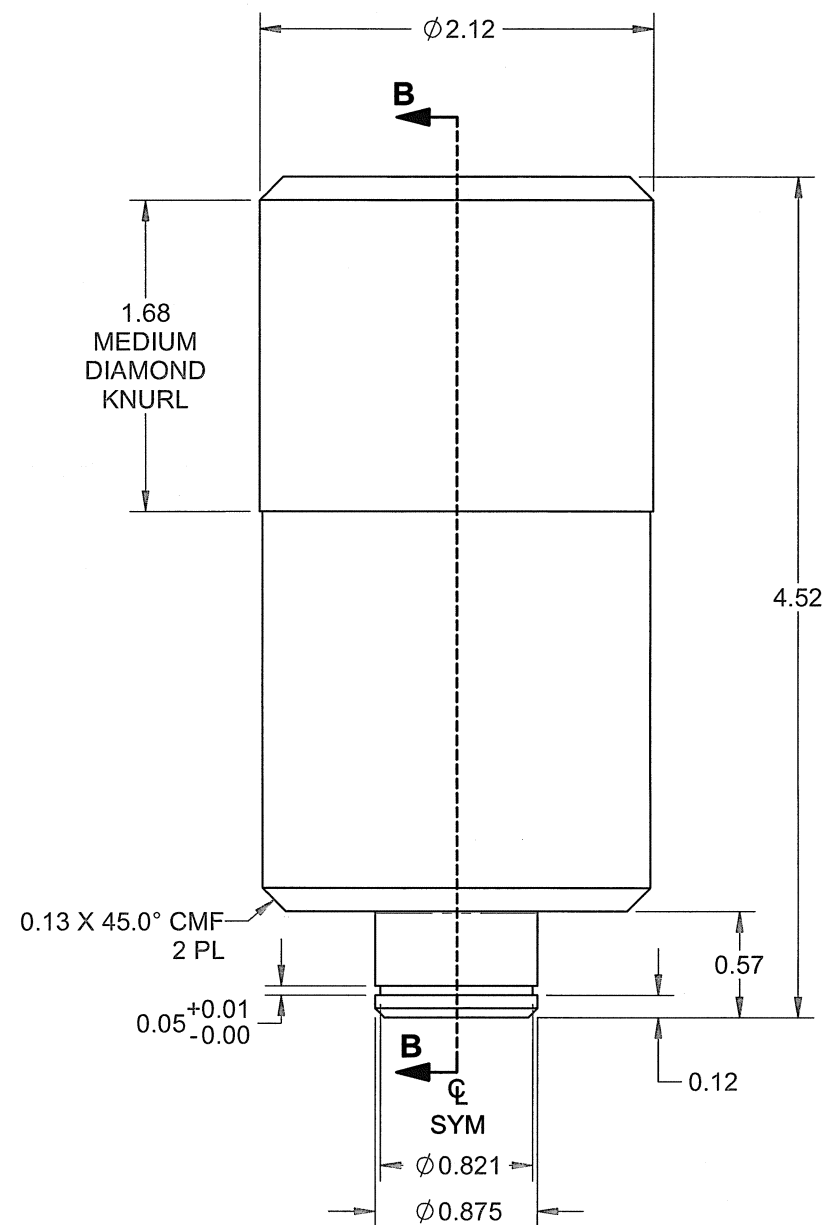
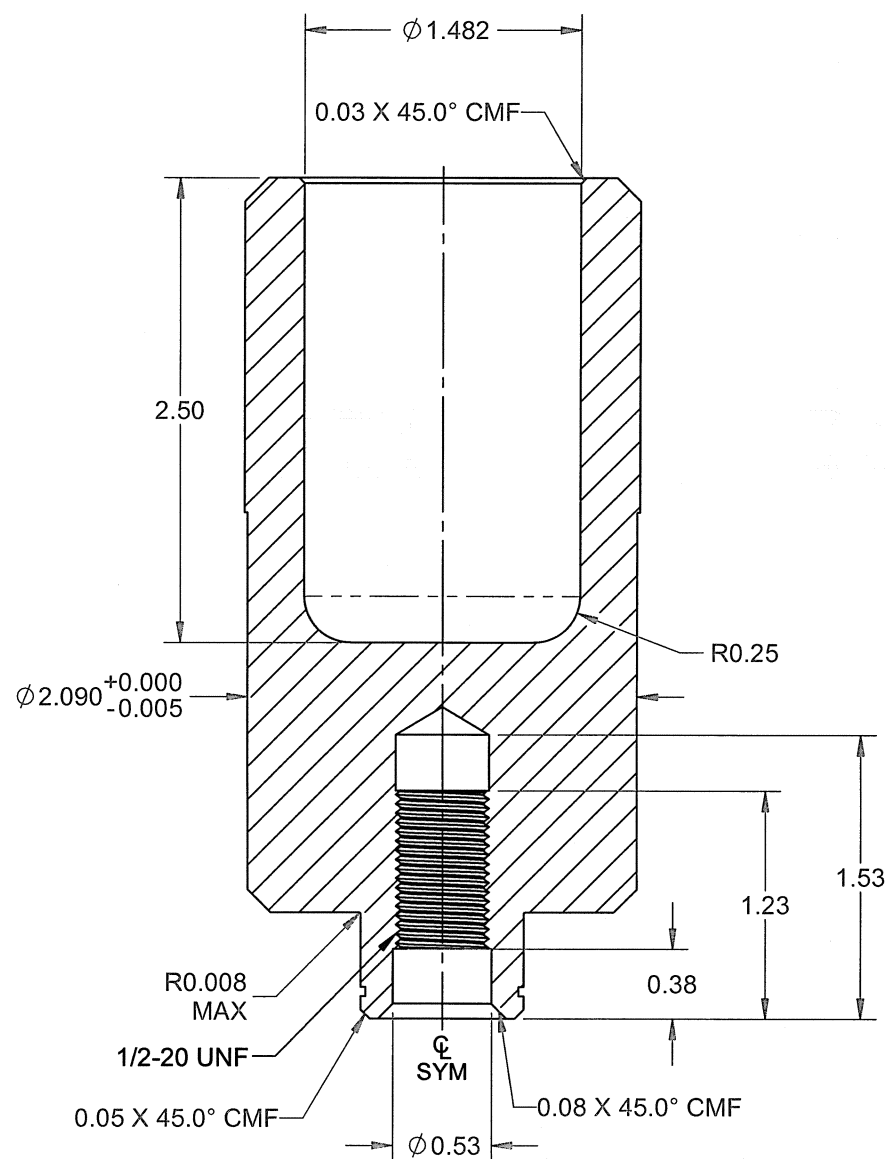
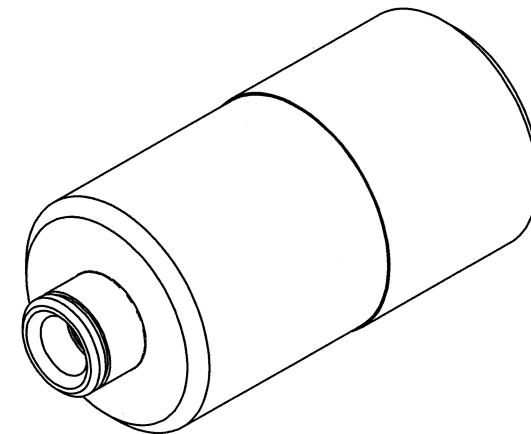
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**RB 92700-10308-041-5 PUSHER****SECTION B-B**

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
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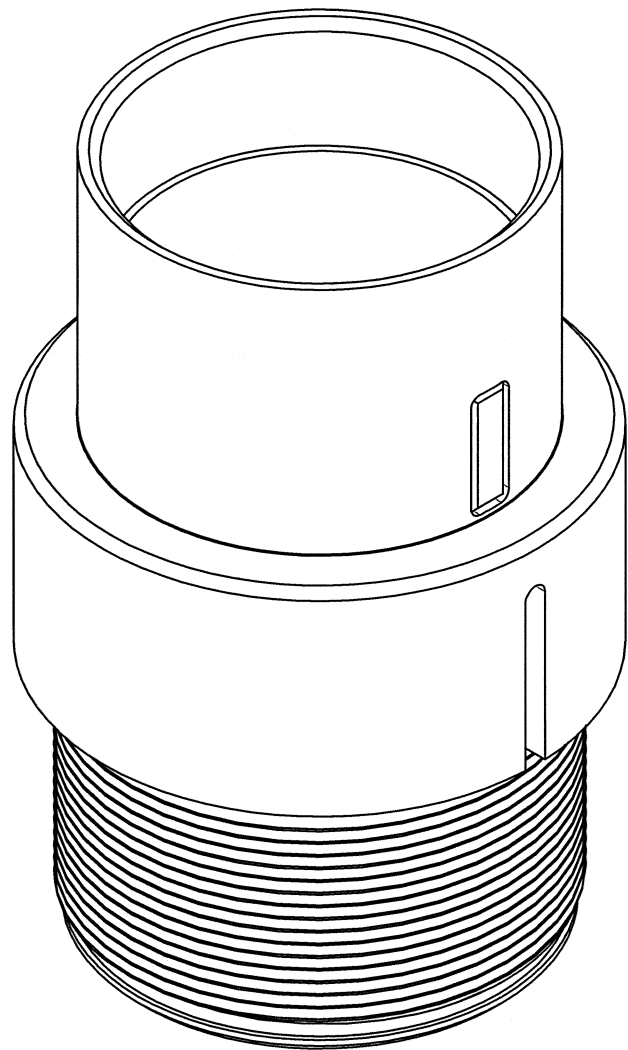
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**NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

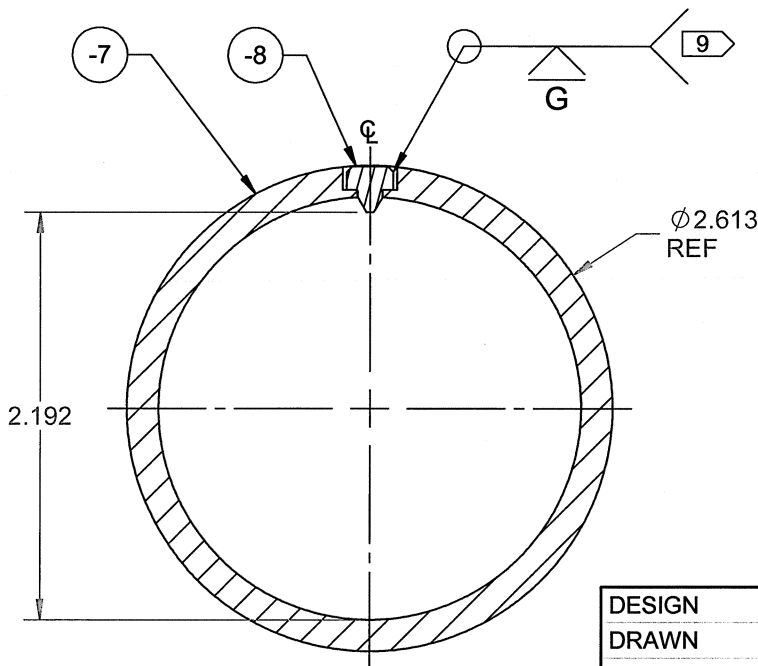
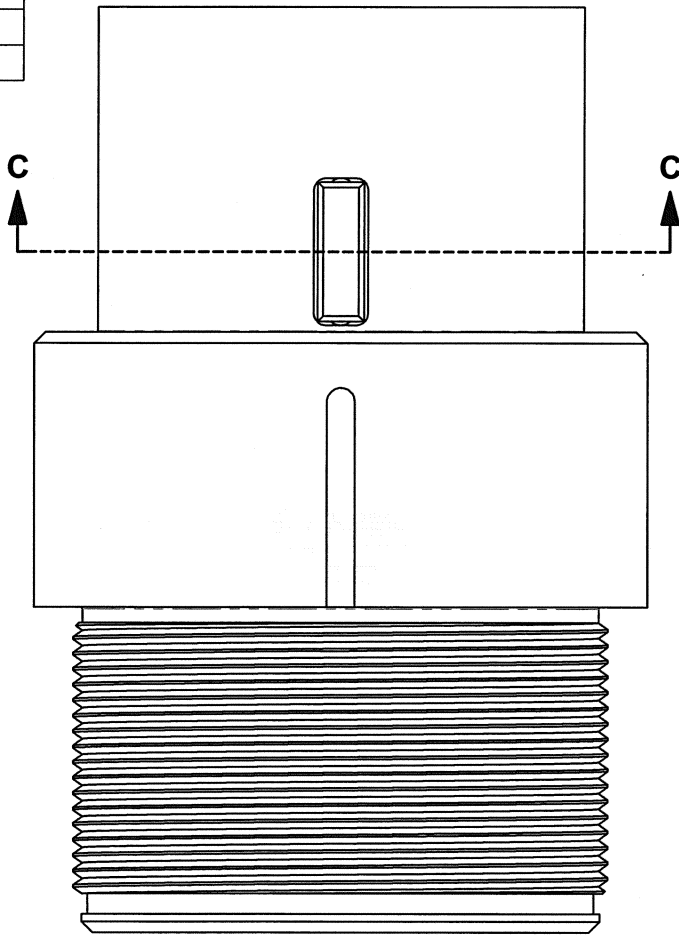
DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 6 OF 12
APPROVED	VR	TITLE	SCALE
		SEAL INSTALLER	NTS 
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ITEM #	QTY	PART #	PART TITLE
-7	1	RB 92700-10308-041-7	SEAL INSTALLER
-8	1	RB 92700-10308-041-8	GEAR ALIGNMENT



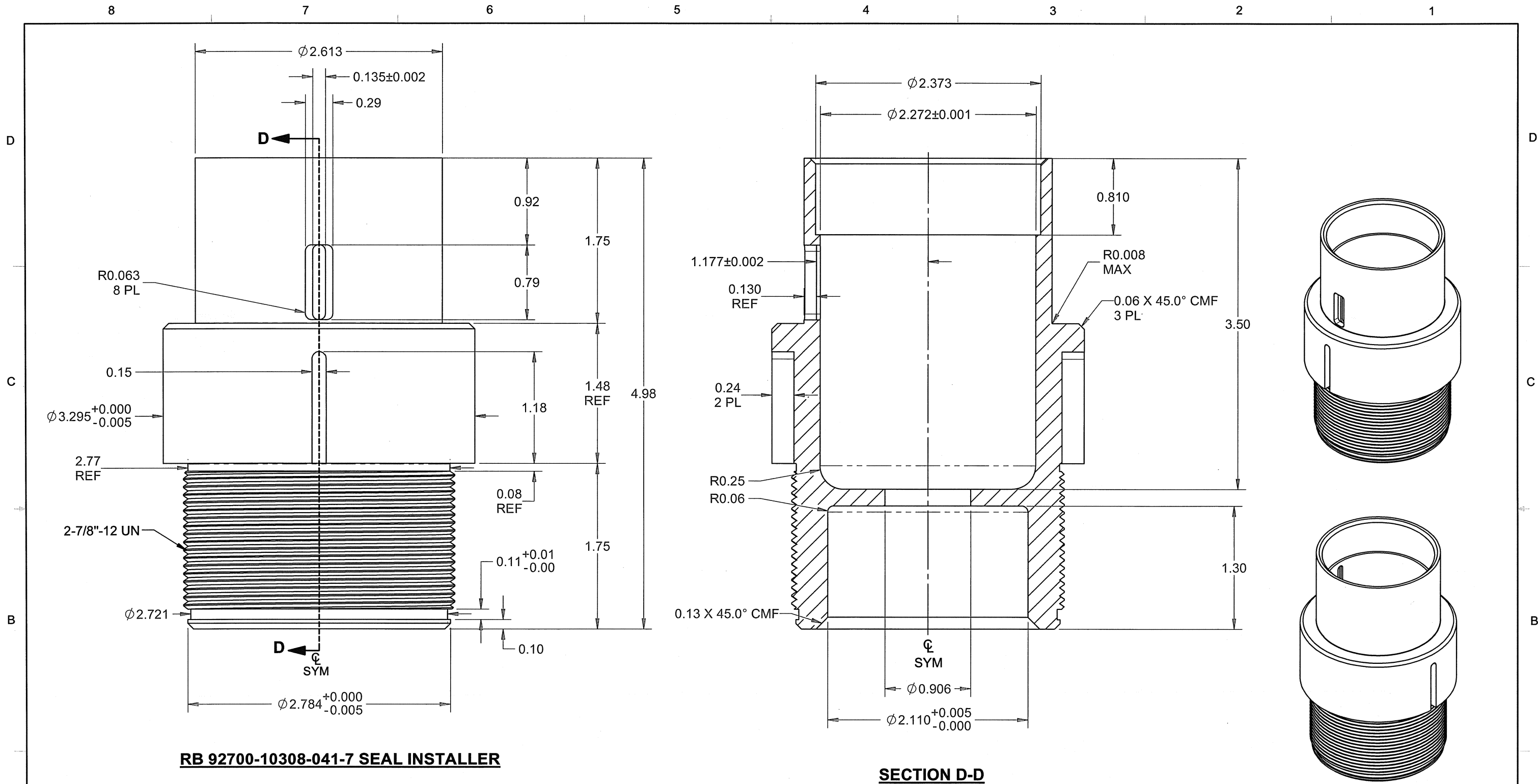
**RB 92700-10308-041-6 SEAL INSTALLER ASSY**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS IF APPLICABLE  
7) IDENTIFICATION: N/A  
8) ASSEMBLE AS SHOWN  
9) GRIND OR MACHINE WELD FLUSH TO SURFACE OF ITEM -7



**SECTION C-C**

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 7 OF 12
APPROVED	VP	TITLE	SCALE
		SEAL INSTALLER	NTS
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- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 8 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		SEAL INSTALLER	NTS
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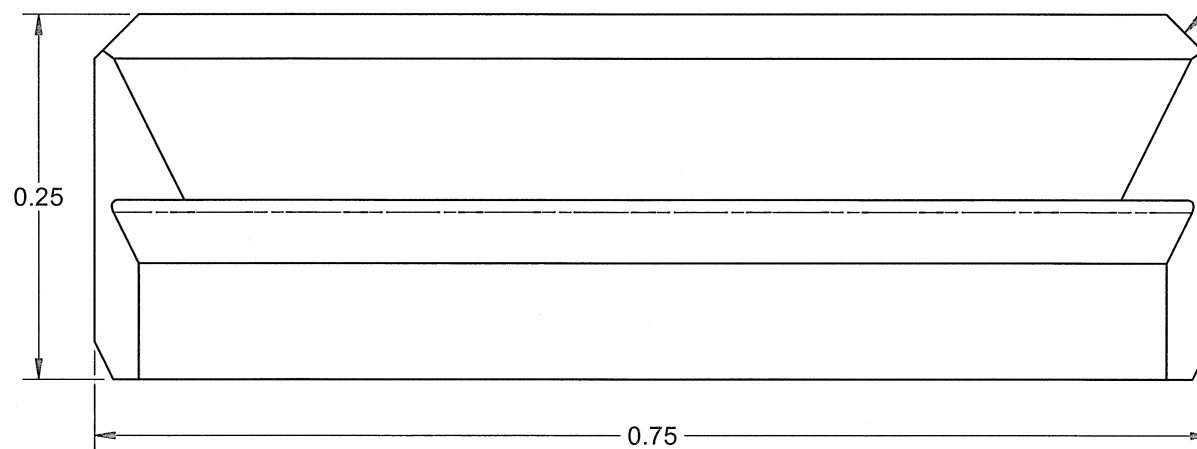
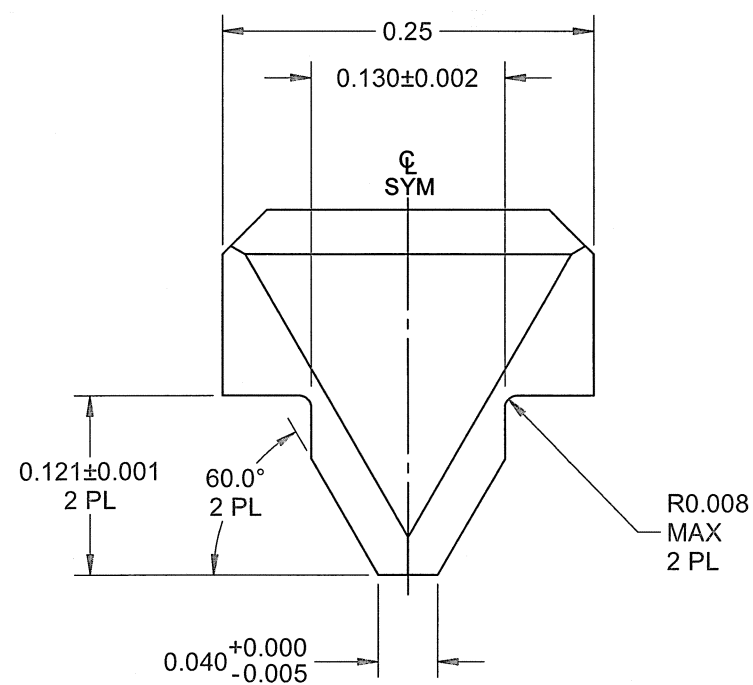
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**RB 92700-10308-041-8 GEAR ALIGNMENT****NOTES:**

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A



3) FINISH: N/A

4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1^\circ$ X.XX =  $\pm 0.01"$  /  $\pm 0.5^\circ$ X.XXX =  $\pm 0.005"$  /  $\pm 0.1^\circ$ X.XXXX =  $\pm 0.0005"$  /  $\pm 0.05^\circ$ PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$ 

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 9 OF 12
APPROVED		TITLE	SCALE
		SEAL INSTALLER	NTS 
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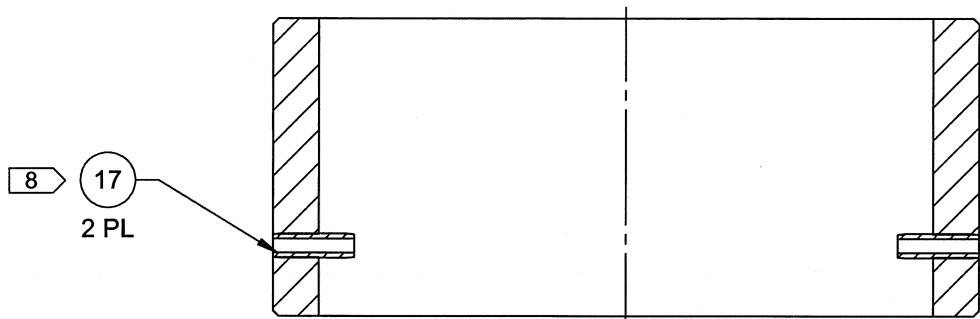
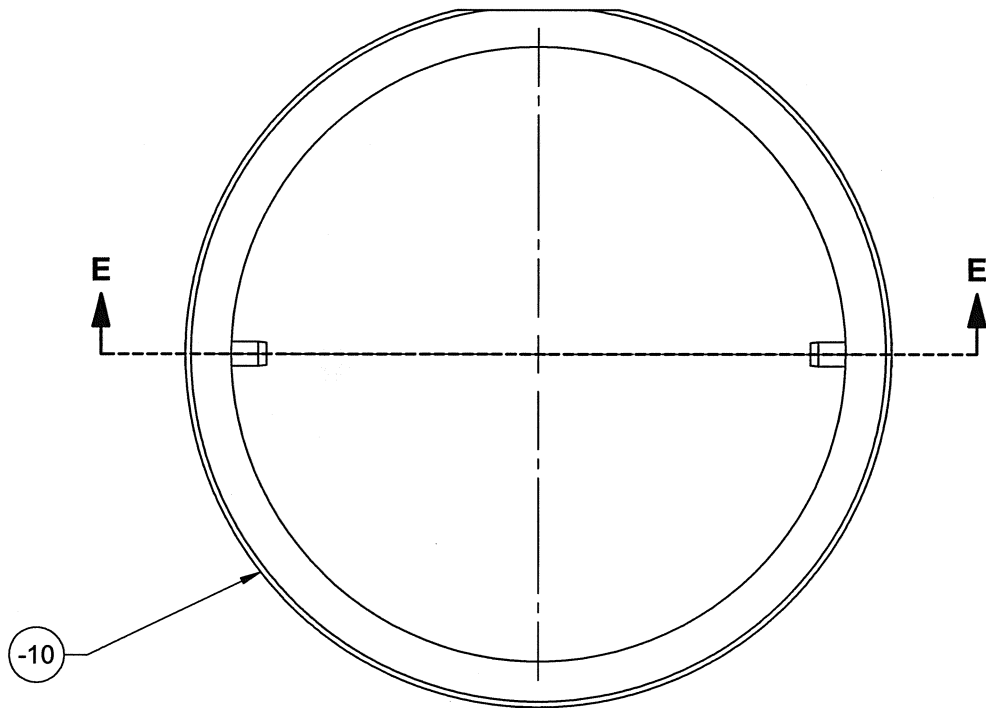
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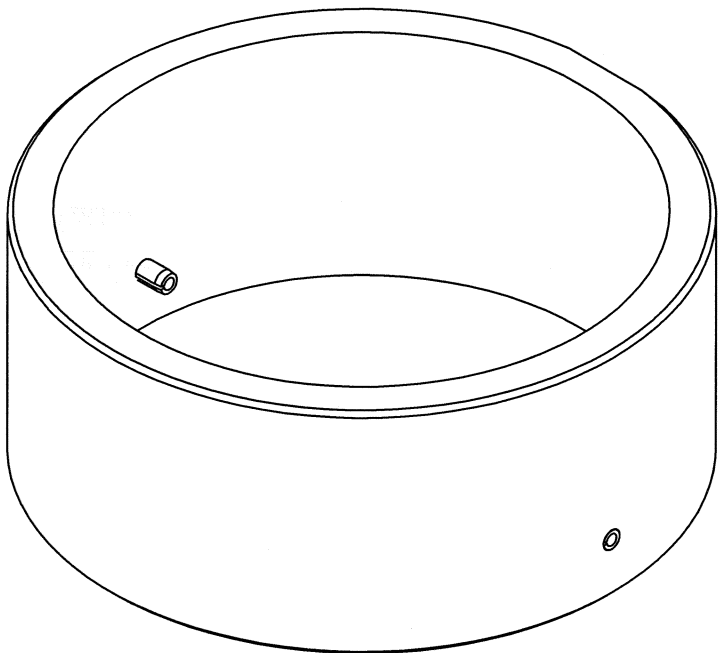
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ITEM #	QTY	PART #	PART TITLE
-10	1	RB 92700-10308-041-10	ALIGNMENT RING
17	2	McMaster#90692A693 OR EQUIV.	STEEL SPRING PIN 1/8" DIA. X 7/16" LG.




**SECTION E-E**



**RB 92700-10308-041-9 ALIGNMENT RING ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 17 FLUSH WITH SURFACE OF ITEM -10 AND REMOVE EXCESS

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 10 OF 12
APPROVED		TITLE	SCALE
DATE 2/11/2019		SEAL INSTALLER	NTS 
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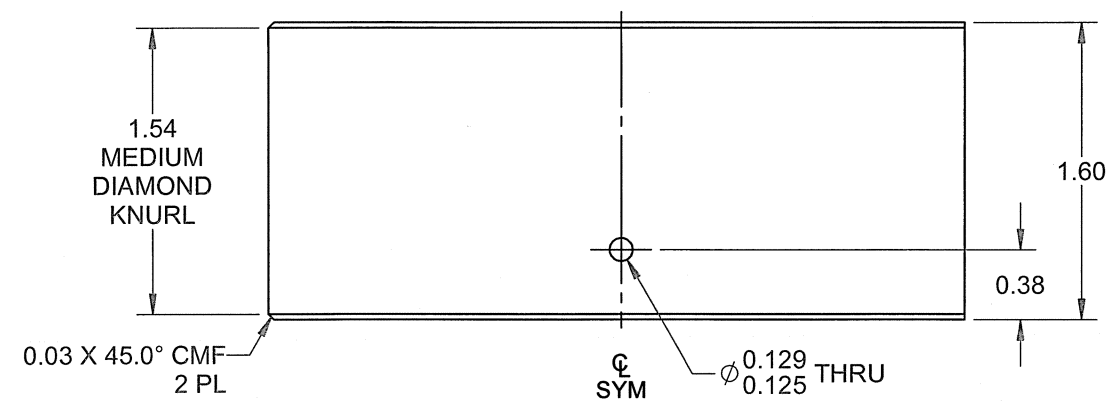
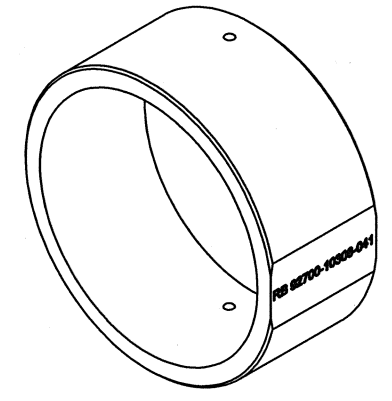
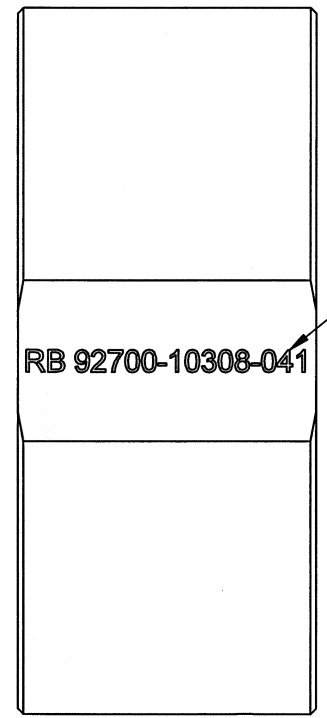
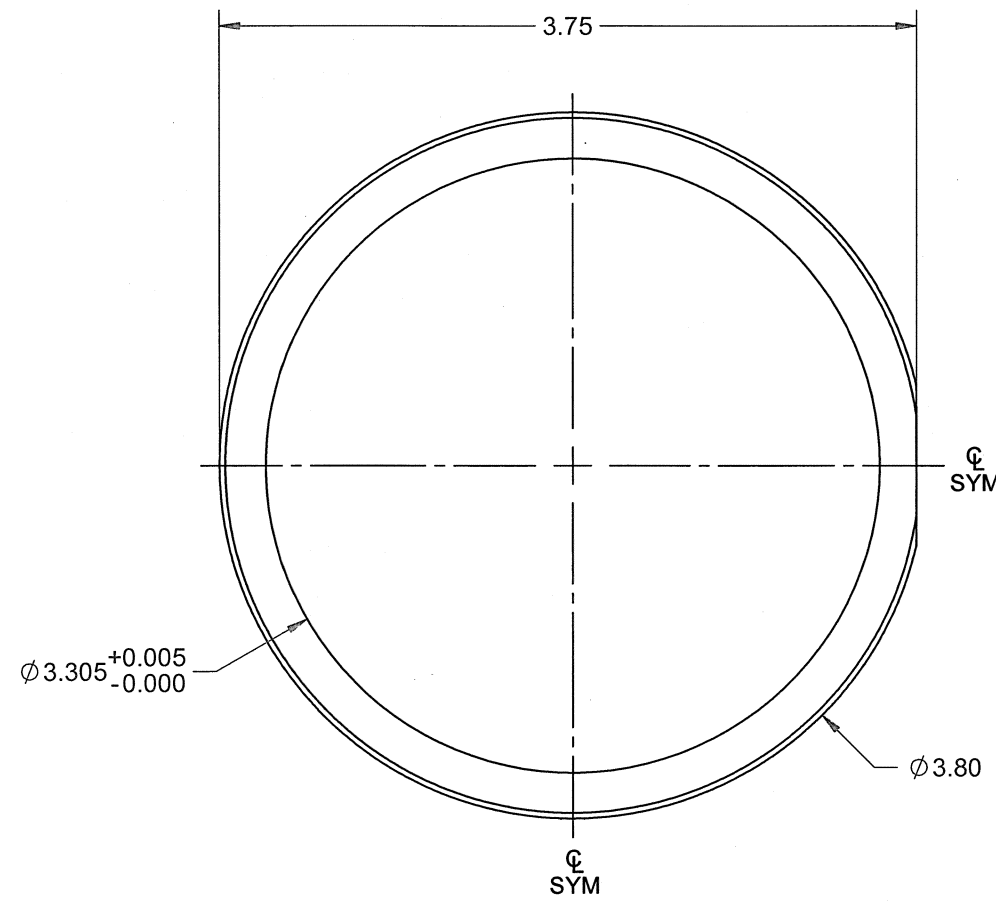
A

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C

B

A



**RB 92700-10308-041-10 ALIGNMENT RING**

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
  - 2) HEAT TREAT: N/A
  - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 11 OF 12
APPROVED	VP	TITLE	SCALE
DATE 2/11/2019		SEAL INSTALLER	NTS
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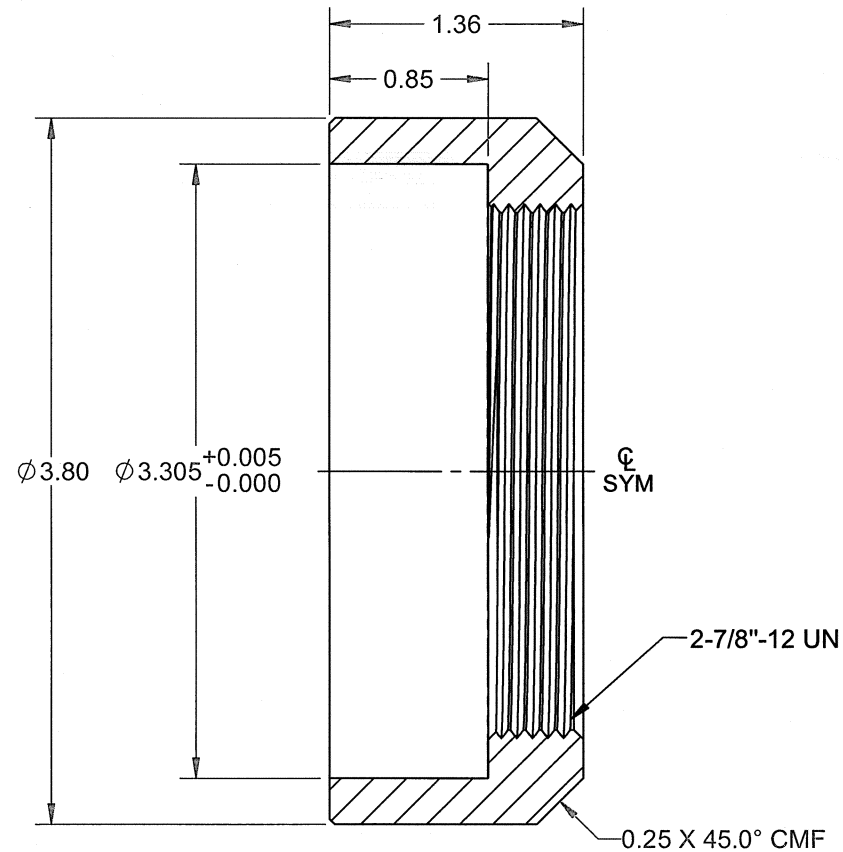
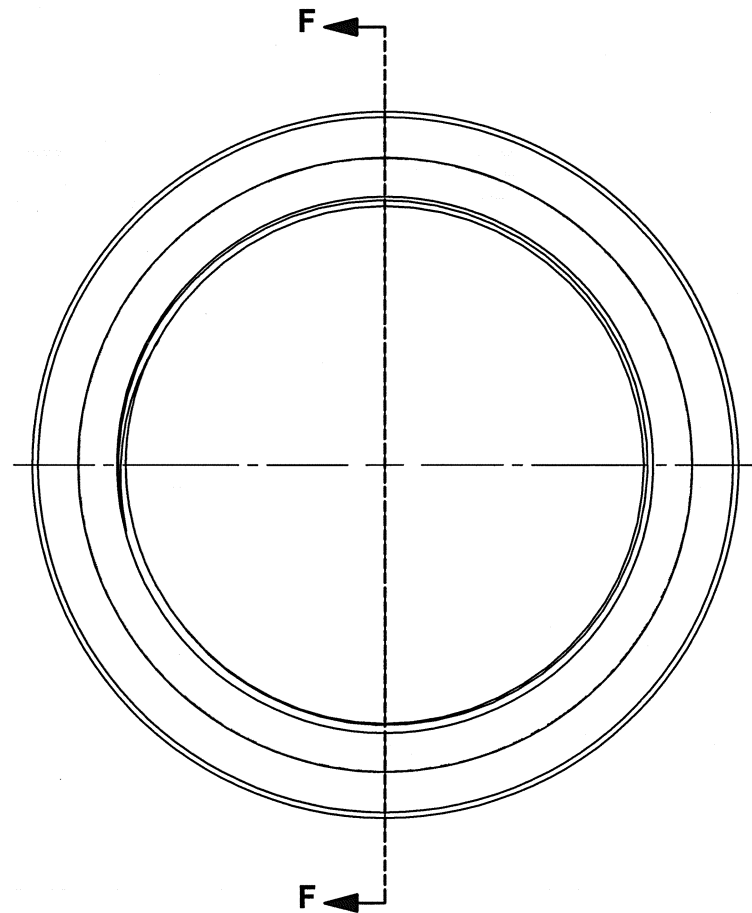
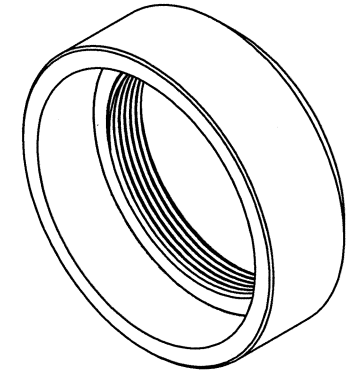
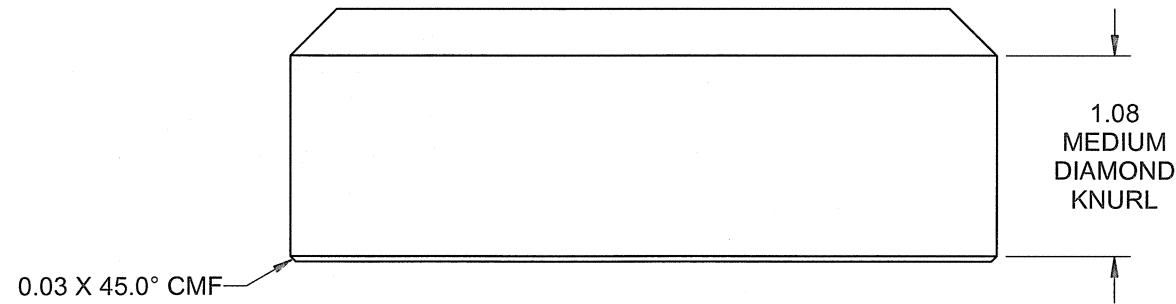
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**SECTION F-F****RB 92700-10308-041-11 THREADED RING****NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. B
MFG. APPR.	DP	RB 92700-10308-041	SHEET 12 OF 12
APPROVED		TITLE	SCALE
DATE 2/11/2019		SEAL INSTALLER	NTS
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